

Date: Wednesday, 1/24/2007 4:49:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B FWD X-TUBE
Job Number	: 30436		
Estimate Number	: 12346		
P.O. Number	: <i>N/A</i>	Part Number	: D206667101
This Issue	: 1/24/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D206-667-141REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 29103	Material	: <i>N/A</i>
		Due Date	: 2/28/2007
Written By	: <i>[Signature]</i>	Qty:	1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: 05.09.01 Add holes for compatibility with Bell Skidtubes KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-101 CHG002

2.0	D6001105	Crosstube
-----	----------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 • D6001-105 Crosstube *B23965*

Check OD = 2.250"; ID = 1.874"

mk 07/02/03

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083

2-Turn first side as per Folio FA083

3-Deburr & Inspect for surface damage.

mk 07/02/04

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA083

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141

Inside of Cuff(Donot engrave on outside of tube)

ML 07/02/04

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ML 07/02/04

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.02.05

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

DP/M 07-02-09

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pac/M 07-02-09

10.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT

EL/RT 7-3-12

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

207-03-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes in tube using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.
- 2-Drill & ream holes as per Dwg D206-667-141 using drill Jig DT8575 & DT8576. Drill all (3) top holes.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.
- 5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.
- 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141.
Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.
- 8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

07-03-13

507-3-13

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

507-3-13

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3406 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C207103123 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

7/13/2 + 0

18.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20703.28 @

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2.1

*****Let tube sit up right for 30mins before hanging*****

P4500-P-23 Base Batch: 104180

P4500-C-23 Catalyst Batch: 104180

Start time: 47:00

Finish: 12:00

2T 07-05-30

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

20705.30 @

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Paint outside crosstube with White Imron as per QSI 005 4.2

Imron 55U white paint

Batch: 1104045

Imron 125S activator

Batch: 104535

Start: 8:30

2T 07-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

RT 07-06-04

23.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch
2 D2856-400(Cut to 6.94") Abrasion Strip

32020

RT 07-06-25

24.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-043 Nut Plate

30449

RT 07-05-30

25.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2873-045 Nut Plate

29852

RT 07-05-20

26.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch
2 D2891-1 Support

28077

RT 06-07-25

27.0

MS20601AD4W8



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch
14 MS20601AD4W8 Rivet

102850

RT 07-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20

Clamp

102712

07-06-25

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-141. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

07-06-25

07-05-30

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

1102115

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

1103446

07-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:49:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B FWD X-TUBE

Job Number: 30436

Part Number: D206667101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M100826

X

35.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M102473

X

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M103694

X

Eff 1/24/07/260

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/06/260

07/06/260

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-101

Location:

PPP Rev:

07/06/260

07/06/260

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/27

Job Completion



07/06/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30436
Description: Crosstube Assembly (206B High Fwd)		Part Number: D206-667-141
Inspection Dwg: D206-667-141 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

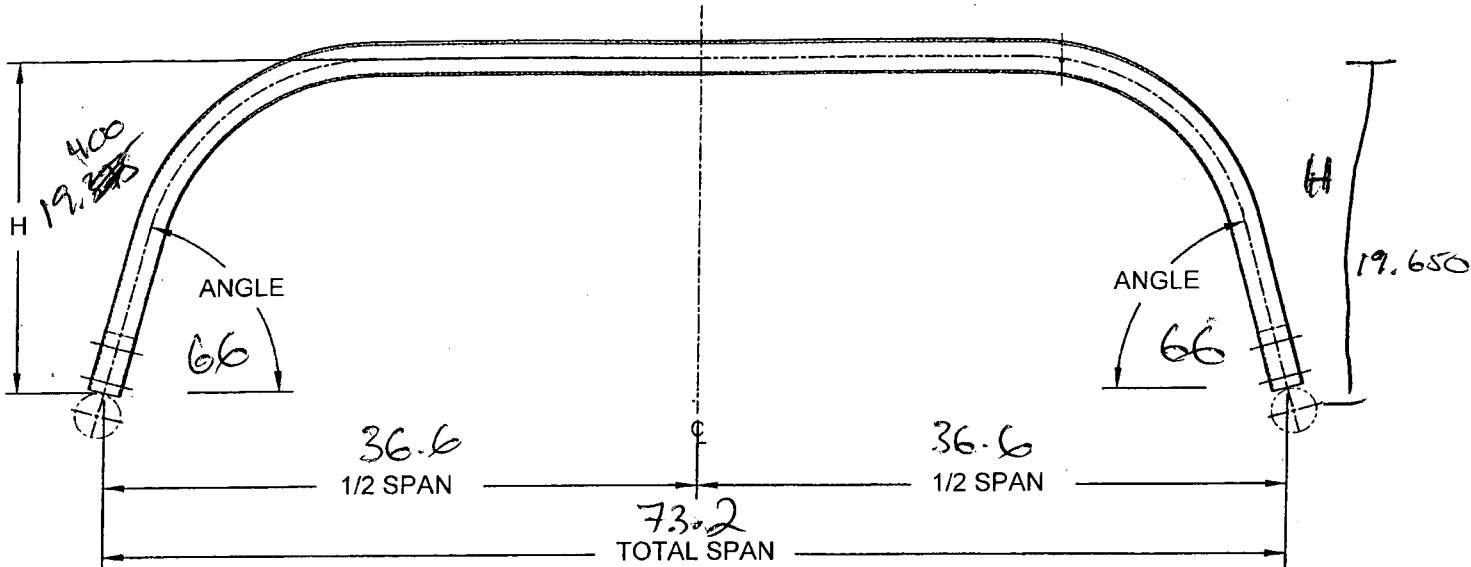
☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	—		
	2.074	+0.005/-0.000	2.077	—		
	2.074	+0.005/-0.000	2.079	—		
	2.114	+0.005/-0.000	2.118	—		
	2.154	+0.005/-0.000	2.159	—		
	2.194	+0.005/-0.000	2.199	—		
	2.234	+0.005/-0.000	2.239	✓		
	0.110	+/-0.010	0.118	—		
	0.300 x 30°	+/-0.010	0.300x30°	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.438	+/-0.030	4.438	—		
SIDE B	2.240	+0.005/-0.000	2.242	—		
	2.074	+0.005/-0.000	2.077	—		
	2.074	+0.005/-0.000	2.079	—		
	2.114	+0.005/-0.000	2.119	—		
	2.154	+0.005/-0.000	2.159	—		
	2.194	+0.005/-0.000	2.199	—		
	2.234	+0.005/-0.000	2.239	—		
	0.110	+/-0.010	0.118	—		
	0.300 x 30°	+/-0.010	0.300x38	—		
	R0.063	+/-0.010	R0.063	—		
	R0.500	+/-0.010	R0.500	—		
	4.438	+/-0.030	4.438	—		
	93.18	+/-0.020	93.195	—		

Measured by: <i>ml</i>	Audited by: <i>SD</i>	Prototype Approval: N/A
Date: 07/02/04	Date: 04.02.05	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM <i>af</i>	<i>BE</i>

Crosstube Bend Dimension Sheet



height is uneven by
 $.250''$ from side to side.

PART NUMBER: D206-667-101

BATCH NUMBER: 30436

DRAWING: -141 REVISION: B

H: 19.54 } $\pm .06$

1/2 SPAN: 36.60

TOTAL SPAN: 73.2

ANGLE: 65 ± 2
-0

QC 15:

DATE: 07-03-12

QTY: 1



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

05.07.26

UNDER REVIEW
06.08.10 PH
re.dwn detail F
PH
07.01.25

Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

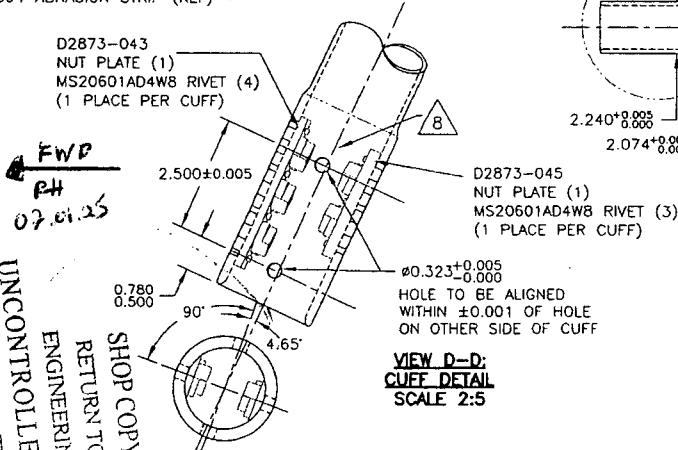
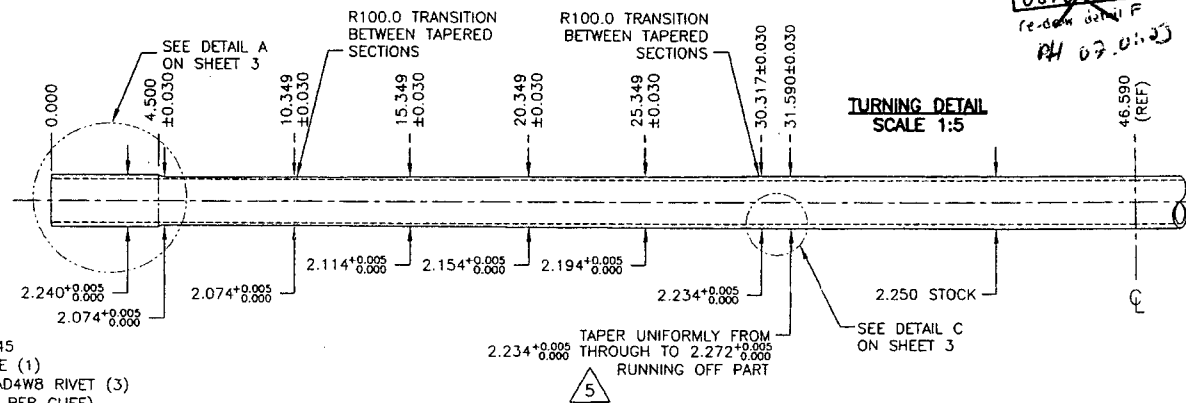
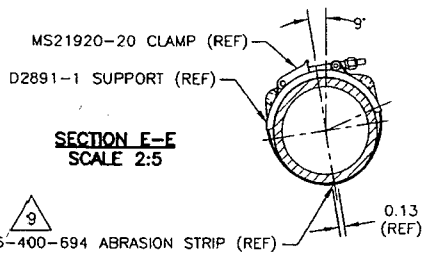
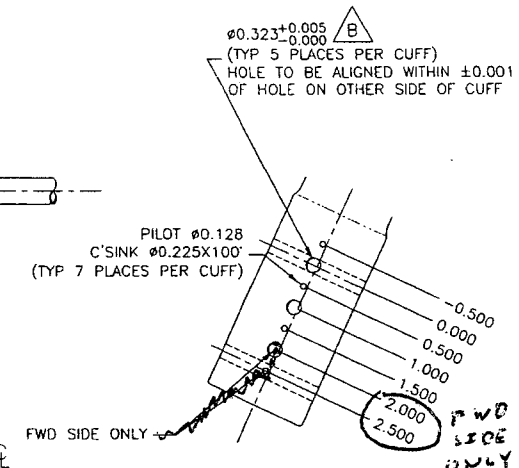
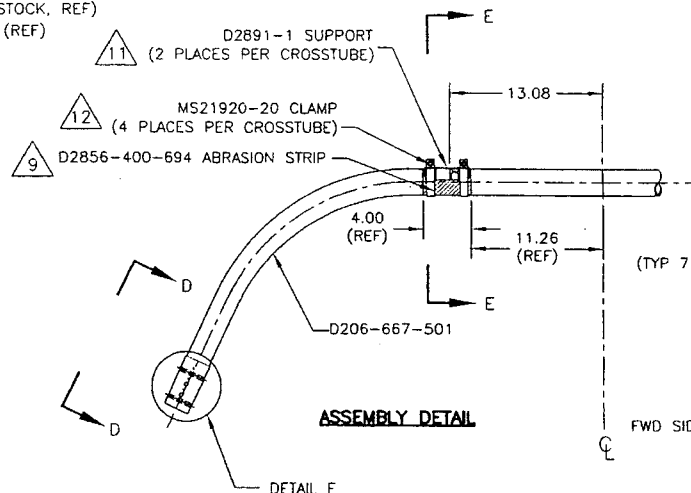
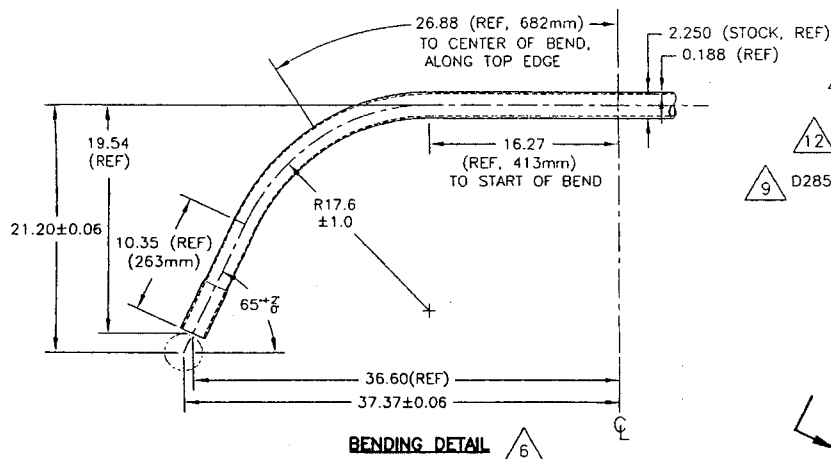
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30436

Copyright © 2000 by DART AEROSPACE LTD

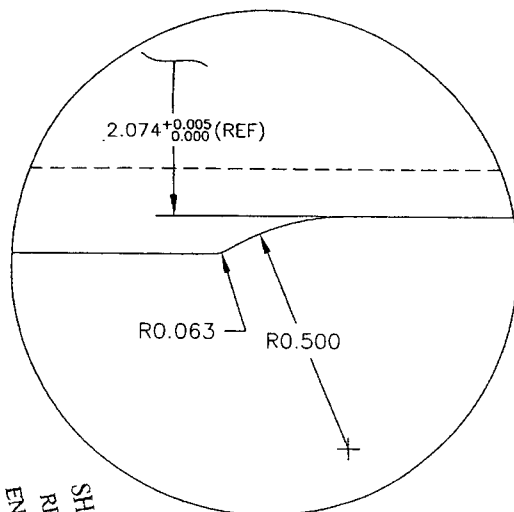
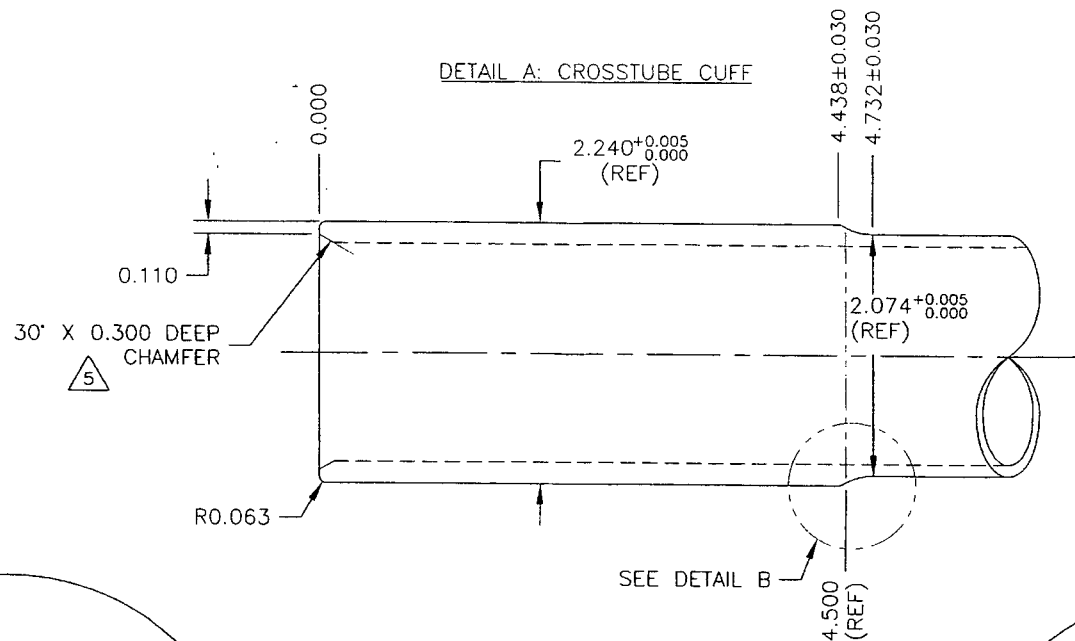
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



UNDER REVIEW
06.08.10 PH
re-own 02.11.10 F
PH 07.01.10

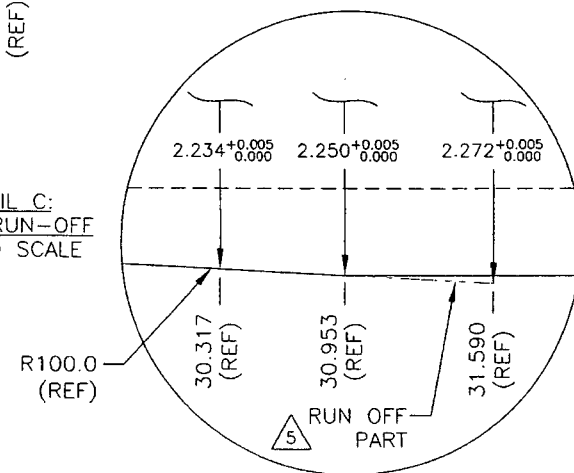
NO. 30436
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-141	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)		SCALE 1:10	



DETAIL C: TAPER RUN-OFF

NOT TO SCALE



UNDER REVIEW

06.03.25 PH

re-draw detail F

PH

07.01.25

05.07.26 #

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN

PH

DRAWN BY

PH

CHECKED

#DS

APPROVED

#US

DATE

05.07.26

DART

DART AEROSPACE LTD.

HAVERSBURY, ONTARIO, CANADA

DRAWING NO.

D206-667-141

TITLE

CROSSTUBE ASS'Y (206B HIGH FWD)

REV. B

SHEET 3 OF 3

SCALE

1:1

NO. 30436

WORK ORDER

WITHOUT NOTICE

SUBJECT TO AMENDMENT

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36034

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038.
Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D212-664-101 S/N's B30419, B30195 and B30417.

Qty (2) P/N D206-667-103 S/N's B30431 and B30430.

Qty (1) P/N D206-667-101 S/N B30436.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(6) cross tubes inspected. (6) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE March 26, 2007

INSPECTION
STAMP(S)

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003406

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$